

**DEPARTMENT OF TRANSPORTATION****DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch

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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.21**WELDING WITNESS REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WWR-000469**Date Inspected:** 22-Nov-2007**Project Name:** SAS Superstructure**OSM Arrival Time:** 630**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1530**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**Witness:** **Procedure Qualification Record**  
**Welding** **NDT****Welder Qualification****Fracture Critical****Mechanical Testing, describe:**Measure minimum leg size for single pass and multiple pass plus Visual Test (VT) of weld properties.**Index Lot #:** L30-139-07**Witness Lot #:** B97-003-07**Bridge No:** 34-0006**Component:** Procedure Qualification Record Testing Samples**Welder:** Zhu Haiping**ID #:** N/A**Joint Description:** Fillet Tee

N/A

**WPS ID #:** PWPS-B-T-3112

N/A

**Base Metal:** ASTM A709 Grade HPS485W

N/A

**PQR ID #:** HP2007261

N/A

**Thickness:** 90mm

N/A

**Process:** SMAW

N/A

**Electrode Spec/Class:** AWS A5.1/E7018-1

N/A

**Positions:** 2F

N/A

**Backing Material:** N/A

N/A

**CWI:** Huang Wei

N/A

**Average Amps:** 213.5

N/A

**AWS Code:** AWS D1.5 (2002)

N/A

**Average Volts:** 24.5

N/A

**Applicable Sec:** AWS Section 5.10

N/A

**Travel Speed:** 112.6 mm/min

N/A

**Heat Input:** 2.79 KJ/mm

N/A

**Preheat:** 187 degrees Centigrade

N/A

**Summary of Items Observed:**

On this date, the Caltrans Quality Assurance (QA) representative, John P. Tracy, performed a witness of Procedure Qualification Record (PQR) mechanical testing samples. The samples had their individual examinations performed and indications of Lack of Fusion were noted. The samples were subsequently rejected by ZPMC. See 04-0120F3\_6034\_B97-003-07 report for further details.

**Summary of Conversations:**

At the completion of the mechanical testing the Certified Welding Inspector / Quality Control Inspector, Huang Wei, of ZPMC reported that the mechanical tests were found to be rejectable in accordance to the criteria set forth with the contractual documents. Further results are pending as of this date.

**Observed welding,testing or results:**

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## WELDING WITNESS REPORT

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is in general conformance with the contract requirements.  
is not in conformance with the contract requirements.

### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Mazen Wahbeh, (818) 292-0659, who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Tracy,John	Quality Assurance Inspector
<b>Reviewed By:</b>	Cuellar,Robert	QA Reviewer

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